

Tuesday, December 06, 2016 2:50:47 PM

Page 1

Stop *NR2*

[illegible]

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Page 2

DAS
36
9-89

16/12/12

Work Order ID 154218

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154218

Page 4

Item ID: D4436-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Inboard Bracket Assembly
Start Date: 11/30/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/6/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
180		0.00								DAS 36 9-89
180						2x			17/01/26	
Small Fab	Memo	0.03								
Small Fab	Assemble as per dwg, do not install grommets and rubber seal.									
185	QC5- Inspect part completeness to step on W/O	0.00								DAS 38 9-89
185						2			JAN 26 2017	
QC	Memo	0.01								
Quality Control										
190	Black Sandtex (Ref: 4.3.5.7) per QSI005 4.3	0.00								
190										
Powdercoat	Memo	0.02								
Powder Coating										

START: 9:15
OUT: 3:20
FINISH: 9:45

2 of 17 01-27 23:38

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[illegible]

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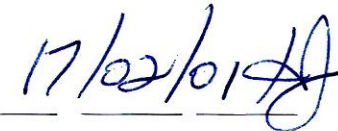
154218

Page 6

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Revision ID: Stop ***NS2***
Item Name: Aft Inboard Bracket Assembly
Start Date: 11/30/2016 Start Qty: 2.00 ***2*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>ST 621</u>	0.00				DAS 30 9-89			JAN 3 2017
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.03							
Quality Control									

17/02/01 

 JAN 31 2017

Picklist Print

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Page 1

Work Order ID: 154218

154218

Parent Item: D4436-045

D4436-045

Parent Item Name: Aft Inboard Bracket Assembly

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA2 EC verified by:JLM IPP REV:C 12.01.24
PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS35489-19		Purchased		No		202	Each	16.0000	1	2			
MS35489-19									**			17-1-30	DAS 19 9-89
Grommet													

Location	Loc Qty	Loc Code
GA	12	
m135390	12	
ST270	4	
121091	4	

M6061T6S.040		Purchased		No		100	sf	272.8100	0.689	1.450526			
M6061T6S 040									**			DAS 46 9-89	16/12/12
6061-T6 .040 Sheet													

Location	Loc Qty	Loc Code
MAT021	272.81	
m135147	0.92	
m135612	38.27	
m135632	84.78	
m135724	148.84	

D4441-1		Manufactured		No		202	f	0.0001	0.31	0.62			
D4441-1									**			17-1-30	DAS 19 9-89
Rubber Seal													

Location	Loc Qty	Loc Code
ST422	0.0001	
120932	0.0001	

15/34/7

Picklist Print

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Work Order ID: 154218

154218

Parent Item: D4436-045

D4436-045

Parent Item Name: Aft Inboard Bracket Assembly

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

D4441-1 Manufactured No f 0.0001 1.682

D4441-1

Rubber Seal

**

17-1-30

DAS
19
9-89

Location Loc Qty Loc Code

ST422 0.0001

0.0001

18,145.00 4

8

**

17/01/26

DAS
36
9-89

MS20426AD3-73 Purchased No 180 Each 18,145.00 4

MS20426AD3-73

Rivet

Location Loc Qty Loc Code

Mezz 18145

1173 8865

13276 9280

180 Each 2,582.000 2

4

**

17/01/26

DAS
36
9-89

MS20470AD4-3 Purchased No 180 Each 2,582.000 2

MS20470AD4-3

Rivet, Universal Head

Location Loc Qty Loc Code

GA 161

2193 161

ST 2421

m135536 2421

180 Each 183.0000 2

4

**

17/01/26

DAS
36
9-89

MS21075L08 Purchased No 180 Each 183.0000 2

MS21075L08

ANCHOR NUT

Location Loc Qty Loc Code

ST298 183

M135774 108

M136182 75

M128635
42

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

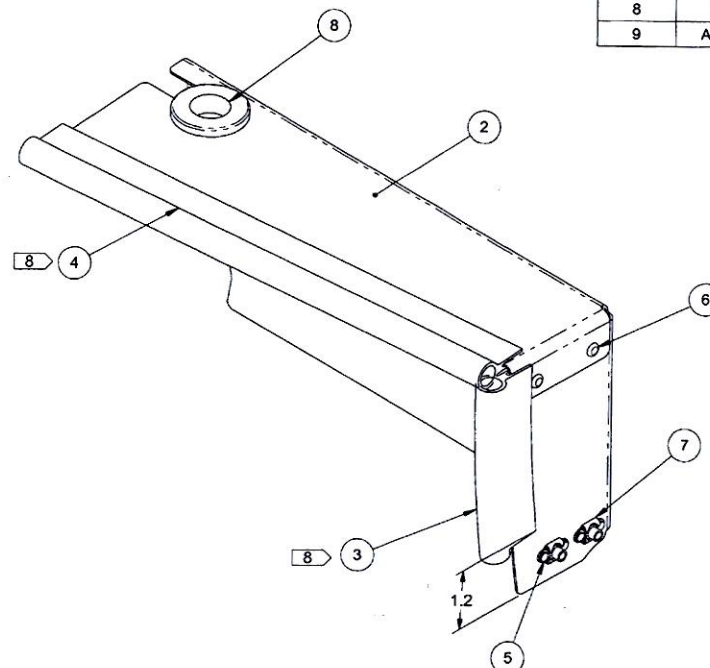
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval				
Description Work Order Deviation			Disposition					
						Completed By		
						Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐				
Misidentified ☐	☐	Past Due	☐				

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

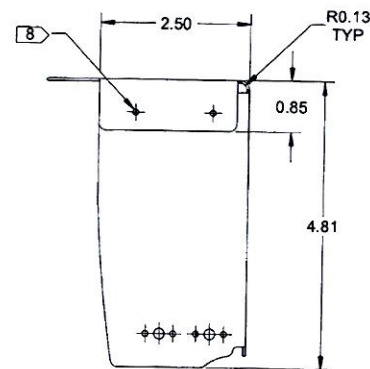
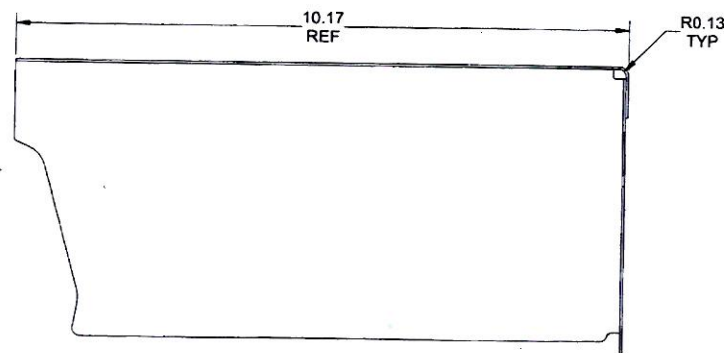
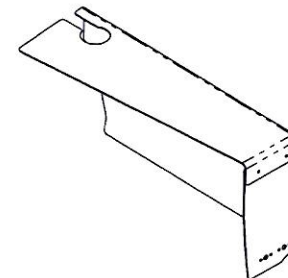
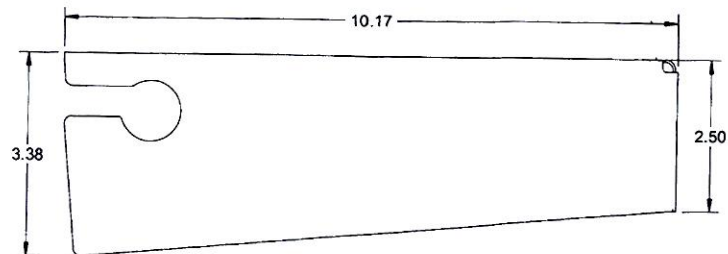
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE,
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154 218 MJS
16-12-07

RELEASED
2012-01-23
MJP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF		SHEET 3 OF 7
APPROVED	RF	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.01.17		



D4436-3 BRACKET

- NOTES:**
- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs
 - 8) TRANSFER $\varnothing 0.129$ HOLES THRU 2 PLACES

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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